

Work Order ID 152181

Wednesday, November 02, 2016 7:44:47 AM

152181

Page 1

Item ID: D4009-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bonding Braid

Start Date: 10/19/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/21/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: **DAS 21** Date: **NOV 01 2016** Tooling: Date:
 QC: **9-89** Date: SPC (Y/N): Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr		DAS						
D4009	A		6	NOV 02 2016	6				
			9-89						

110 Pick Kit 0.00

110

Packaging Memo 0.24

Packaging

120 0.00

120

Small Fab Memo 0.24

Small Fab Assemble as per dwg D4009 and install label

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC Memo 0.02

Quality Control

P.T.O.

DAS
38
9-89

NOV 03 2016

DAS
36
9-89

DQA:

Date: 2017-05-25



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: APR 06 2017

Work Order update only ☐

Work Order: <u>152181</u>	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>D4009-041</u>	Rework ☒	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒	
NCR No. <u>17-6368</u>	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		
Date: <u>16-11-03</u>	Step #: <u>120</u>	QTY Effective: <u>6</u>			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			DAS <u>9</u> 9-89 16-11-03	
Braid is too small to wrap D2728-4 around		I.D. as per QSI044 6.6 (green tag)			Completed By DAS <u>38</u> 9-89	
I.D. with label is not applicable.		open PAR. to remove note 6 on drawing			Lead hand / Supervisor Approval Verification DAS <u>9</u> 9-89 16-11-03	
Root Cause		FAULT CATEGORY				
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	☒ Fit/Function	Misread ☐	
Substation ☐	☒ Process Improvement	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	
Past Expiry Date ☐	Manufacturing Process ☐					
Misidentified ☐	Past Due ☐	OTHER: ☐				

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QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>St671</u>	0.00							
140									
Packaging	Memo	0.01							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.10							
Quality Control									

b DAS
6
9-89 NOV 07 2016

16/11/8 7A

DAS
21
9-89

NOV 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																		
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Picklist Print

Wednesday, November 02, 2016 7:44:52 AM

Page 1

Work Order ID: 152181

Parent Item: D4009-041

Parent Item Name: Bonding Braid

152181

D4009-041

Start Date: 10/19/2016

Required Date: 10/21/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev A 10.02.02 new issue Prelim EC verified by:DD IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2182-045		Manufactured	No				Each	0.0000		6			
D2182-045 Heat Shrink 4.5" Long									**				
D2729-4		Manufactured	Yes				Each	0.0000		6			
D2729-4 Red Decal									**				
D4009-1		Manufactured	No				Each	18.0000		12			
D4009-1 Terminal End									**				
										DAS 6 9-89		NOV 02 2016	
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST070	18								
				144483	18								
D4009-3		Manufactured	No				Each	24.0000		6			
D4009-3 Ground Strap									**				
										DAS 6 9-89		NOV 02 2016	
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST070	24								
				112347	24								
D4009-5		Manufactured	No				Each	27.0000		6			
D4009-5 Ground Strap									**				
										DAS 6 9-89		NOV 02 2016	
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				GA	9								
				115076	9								
				ST071	18								
				112434	18								

REASON: BRAID
IS TOO SMALL TO
WRAP
D2729-4 ALREADY
AND HEAT SHRINK.
WON'T BE LEGIBLE.
ID PER ASI 044 G.6.

DAS
22
9-89
16.11.02

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Start Date: 10/19/2016

Required Date: 10/21/2016

Start Qty: 6.00

Required Qty: 6.00

D4009-7

Manufactured No

Each

66.0000

6

D4009-7

Tab

**

DAS

6
9-89

NOV 02 2016

Location

Loc Qty

Loc Code

ST071

66

121538

66

Each

45.0000

6

DAS

6
9-89

NOV 02 2016

D4009-9

Manufactured No

D4009-9

Receptacle

**

Location

Loc Qty

Loc Code

ST071

45

113166

45

6

DQA: _____ Date: _____

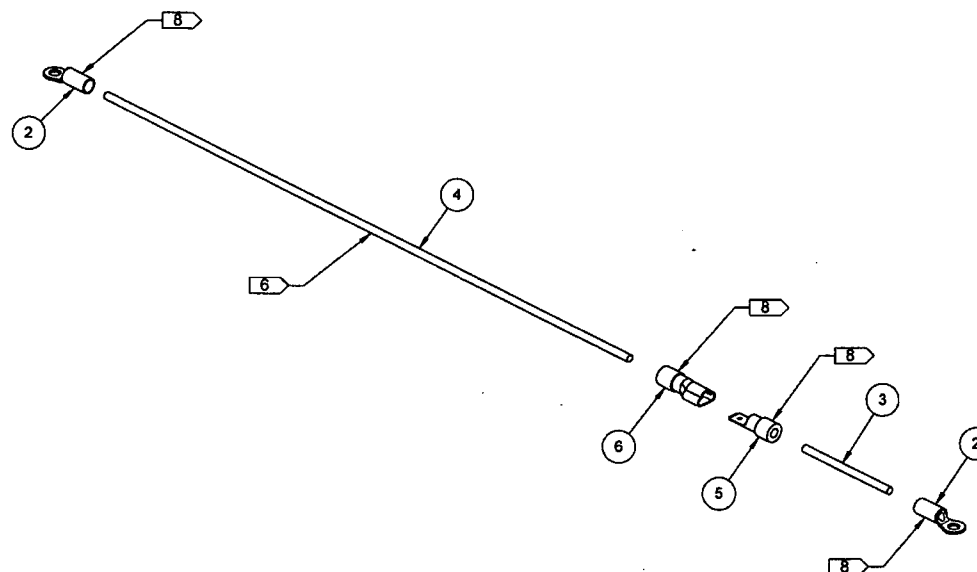
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								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4009-041	BONDING BRAID	JCA-M47-4-01
2	2	D4009-1	TERMINAL END	
3	1	D4009-3	GROUND STRAP	
4	1	D4009-5	GROUND STRAP	
5	1	D4009-7	TAB	
6	1	D4009-9	RECEPTACLE	



D4009-041 BONDING BRAID

RELEASED
2010-05-05
MD

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4009-041" AND B/N USING D2729-1 LABEL INSTALLED WITH D2182-045 HEAT SHRINK
 - 7) WEIGHT: N/A
 - 8) USE CRIMPING TOOL P/N 59824-1

A	NEW ISSUE		10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.05		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4009	REV. A SHEET 1 OF 5
TITLE GROUND STRAP	SCALE NTS
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